

Date: Wednesday, 5/23/2007 3:24:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 32471		Part Number	: D31991	
Estimate Number	: 10283		Drawing Number	: D3199 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/23/2007	S.O. No. : <i>N/A</i>	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: <i>N/A</i>		Due Date	: 6/10/2007	
Previous Run	: 31657		Qty:	50	Um: Each
Written By	: <i>DL</i>		Comment		
Checked & Approved By	: <i>DL 07.05.24</i>		Est Rev:C	Removed Scribing	05-11-05
			Est Rev:D	As per Rev B	06-11-24
			JLM		
Additional Product					

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 0.1040 sf(s)/Unit Total : 5.1975 sf(s) 304/316 .040" SHEET Batch: <u>M104640</u> <i>M1 07 06 08</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: <u>B</u> <i>M1 07 06 08</i> Prog Rev: <u>B</u>
		Deburr if required
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>M1 07 06 08</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>50-06-12</i> counted.
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 <i>SP 07/06/20</i>

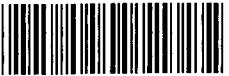
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/29
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 32471		Part Number: D31991
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP  <i>1/18/07/06/20 X500</i>
7.0	POWDER COATING	POWDER COATING  <i>m/14846 BR/m/p 07-06-28</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>1/7/07/29</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>1/6/29 SP/1 50x</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>1/7/07/29</i>
Job Completion 		<i>C 207/06/29</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32471
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>M. M.</i>	Audited by:	<i>J.</i>	Prototype Approval:	N/A
Date:	07.06.08	Date:	07.06.12	Date:	N/A

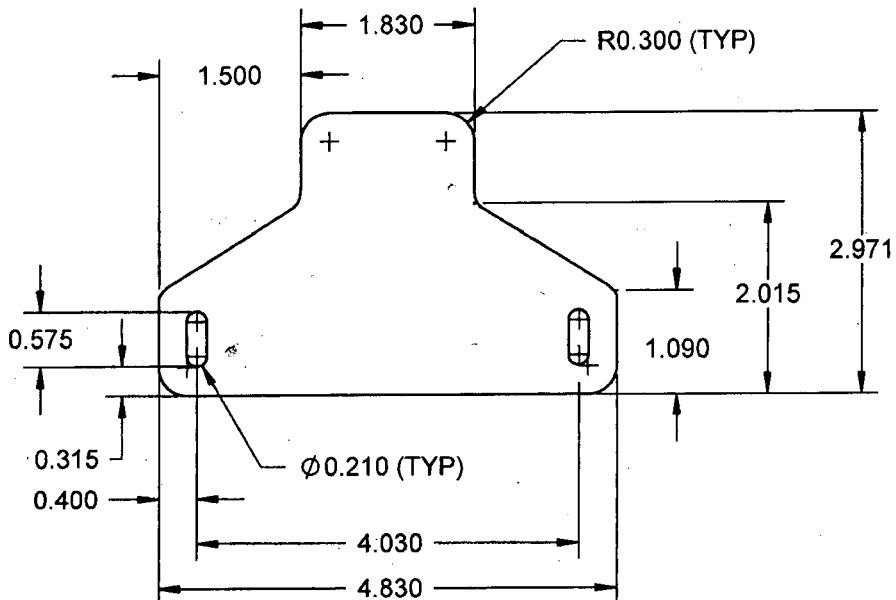
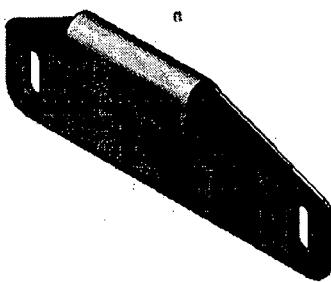
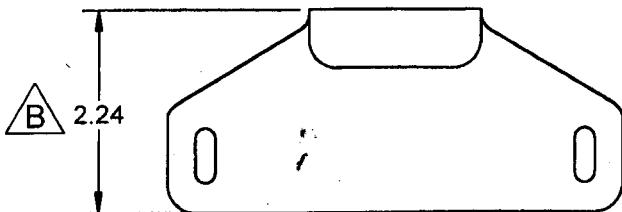
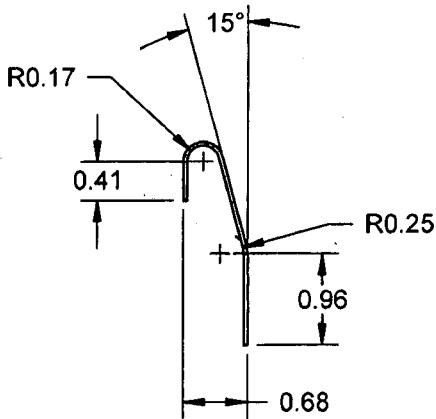
Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	<i>KJ</i> <i>EZ</i>

DART

DESIGN	QP	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	HH	DRAWING NO. D3199
DATE	06.11.01			REV. B SHEET 1 OF 1
				SCALE 1:2
REV	DATE	DESCRIPTION		
A	03.08.05	NEW ISSUE		
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG		

RELEASED

06.11.01

**D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) **ANNEALED**
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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 WITHOUT NOTICE
 WORK ORDER
 NO. 32471